



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4034-041
Job Sheet 181119



Part No: D4034-041

Job Qty: 4 ea

DAS
21
9-89

Part Name: Aft Upper Rib Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/20/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEETS 1,2 IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA
10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER
DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	8/3/18	8/3/18	0.00	0.00	Start Up Large Fab-6		DG 2018-08-10
100	Large Fab	4 pcs	8/3/18	8/3/18	0.00	4.60	Large Fab 1		DG 2018-08-10
110	QC	4 pcs	8/3/18	8/3/18	0.00	0.00	QC9		
120	QC	4 pcs	8/3/18	8/3/18	0.00	0.00	QC5		
130	Packaging	4 pcs	8/3/18	8/3/18	0.00	0.00	Packaging3 Large Fab		
140	QC21-SA	4 Ea	8/3/18	8/3/18	0.00	0.00	QC21		DAS 21 AUG 13 2018

Part Op 100 - 1- Assemble ribs to hoop and weld as per dwg DT9564 2- Weld bushing in rib and grind weld flush as per dwg
Descriptions: 130 - LOCATION: WA004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-7	Hoop	4 Ea (1 ea)	90-Start up Operation	5070657 5084729
D4021-9	Bushing	16 Ea (4 ea)	90-Start up Operation	5098658
D4034-1	Rib	4 Ea (1 ea)	90-Start up Operation	5082358
D4034-3	Rib	4 Ea (1 ea)	90-Start up Operation	5089545

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4021-7	4	29	0
	D4021-9	16	2	0
	D4034-1	4	27	0
	D4034-3	4	17	0

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ifications

I not be found.

Plex 7/20/18 2:35 PM Dart.lajeunesse.marie



Container No: S100984



Part: D4034-041

Job No: 181119

Serial No/Batch: S100984

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/10/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					